



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5425-043

Job Sheet 168535



Part No: D5425-043

Job Qty: 1 ea

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/16/17

Job Tracking No:

Due Date: 12/29/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/26/17	0.00	0.00	Start Up Skidtubes		
110	Skidtubes	1 pcs		12/27/17	0.00	8.24	Skidtubes		
120	CNC Vertical Machining	1 pcs		12/28/17	0.00	22.77	HAAS1-4		
130	QC	1 pcs		12/28/17	0.00	0.00	QC2		
140	QC	1 pcs		12/28/17	0.00	0.00	QC8		
150	HandFinish	1 pcs		12/28/17	0.00	0.24	HandFinish1		
160	QC	1 pcs		12/28/17	0.00	0.00	QC7		
170	CNC Bend Skidtubes	1 pcs		12/28/17	0.00	2.63	CNC Bend Skidtube		
180	QC	1 pcs		12/28/17	0.00	0.00	QC5		
190	Skidtubes	1 pcs		12/28/17	0.00	8.24	Skidtubes		
200	QC	1 pcs		12/28/17	0.00	0.00	QC5		
210	HandFinish	1 pcs		12/28/17	0.00	0.24	HandFinish6		
220	QC	1 pcs		12/28/17	0.00	0.00	QC7		
230	Skidtubes	1 pcs		12/28/17	0.00	8.24	Skidtubes		
240	QC	1 pcs		12/28/17	0.00	0.00	QC5		
250	HandFinish	1 pcs		12/28/17	0.00	0.24	HandFinish6		
260	QC	1 pcs		12/28/17	0.00	0.00	QC7		
270	SprayPaint	1 pcs		12/28/17	0.00	0.00	Spray Paint		
280	QC	1 pcs		12/28/17	0.00	0.00	QC14		
290	HandFinish	1 pcs		12/29/17	0.00	0.24	HandFinish4		
300	QC	1 pcs		12/29/17	0.00	0.00	QC5		
310	Packaging	1 pcs		12/29/17	0.00	0.00	Packaging3		
320	QC21-SA	1 Ea		12/29/17	0.00	0.00	QC21		

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Deburr ends as per Dwg.

Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: 1A FOLIO REV: DA 2-Deburr as per Dwg.

150 - 1-Scrub inside of tube with medium scotchbright.

170 - 1-Bend Aft end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at " from aft end. Use buggy A,B,C AND DT A & B. to stabilize tube. HEIGHT 2-Bend Forward end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at " from fwd end. Use buggy A,B,C AND DT A & B. To stabilize tube. HEIGHT 3-Record dimensions on work order.

180 - #NAME?

190 - 1-Drill remaining holes of section I-I using DT 2-Drill remaining holes of section J-J using

DT 3-Open holes to finished size as per Dwg. 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.

230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B Start

DAS

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P10: 038908

Time: 2:00 Finish Time: 18-01-27 CURE TIME 8 HRS. BEFORE PROCEEDING TO NEXT STEP***
 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 250 - ***DO NOT SUBMERGE TUBE IN DEOXIDIZER***
 270 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND
 QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT
 BATCH: _____
 290 - 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B M138654 Exp: 18/04 Start time: _____
 Finish time: _____ 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.
 A/R LPS Procyon B M133690

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 Ea (1 ea)	90-Start up Operation	
D5518-1	Crossbolt Spacer	18 Ea (18 ea)	230-Skidtubes	<u>S018582</u>
D5512-1	Crossbolt Spacer	12 Ea (12 ea)	230-Skidtubes	<u>S011757</u>
AN3C5A	Bolt	6 Ea (6 ea)	290-HandFinish	<u>S019396</u>
D3672-1	Washer, Phenolic	6 Ea (6 ea)	290-HandFinish	<u>F150074</u>
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-HandFinish	<u>S004889</u>
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-HandFinish	<u>S004945</u>
NAS1149C0332R	Washer	6 Ea (6 ea)	290-HandFinish	<u>S019380-1</u>

Part Specifications

Specifications could not be found.

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DART
 AEROSPACE
S031462



Float Skidtube Assembly

Dart Aerospace Ltd.

1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

PART NO: D5425-043

Original Serial #: S031462

Revision:

Operation: Skidtubes

Change No:

Mfg Date: 01/11/18

Job No: 168535

DART AEROSPACE LTD		Work Order:
Description: Float Skid Tube		Part Number: D5425-043
Inspection Dwg:	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	±0.010	0.500	✓		Kt-05	vern.
2.790	±0.010	2.790	✓		"	"
10.790	±0.010	10.790	✓		CNC-02	vern
14.790	±0.010	14.790	✓		tape	—
43.116	±0.010	43.116	✓		↓	↓
44.866	±0.010	44.866	✓			
48.366	±0.010	48.366	✓			
60.366	±0.010	60.366	✓			
64.366	±0.010	64.366	✓			
74.366	±0.010	74.366	✓			
121.069	±0.010	121.069	✓			
123.324	±0.010	123.324	✓			
125.866	±0.010	125.866	✓			
127.616	±0.010	127.616	✓			
129.366	±0.010	129.366	✓			
131.116	±0.010	131.116	✓			
134.616	±0.010	134.616	✓			
136.366	±0.010	136.366	✓		↓	↓
0.500	±0.010	0.500	✓		Kt-05	vern
2.690	±0.010	2.690	✓		"	"
4.690	±0.010	4.690	✓		"	"
18.690	±0.010	18.690	✓		tape	—
15.24	±0.030	15.24	✓		"	"
R1.0	±0.100	R1.0	✓		R-G	—
0.350	±0.005	0.348	✓		machine	—
0.350	±0.005	0.349	✓		"	"
R1.0	±0.100	R1.0	✓		R-G	—
13.71	±0.030	13.71	✓		tape	—
0.152	±0.015	0.142	✓		machine	—
0.250	±0.015	0.247	✓		"	"
9.35	±0.030	9.35	✓		tape	—
0.350	±0.005	0.3485	✓		machine.	—

Measured by: 1 Kt	Checked by: [Signature]	QC Inspector:
Date: 18-01-19	Date: 18/01/22	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038908**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038908
PO Date: 1/30/18
Due Date: 1/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		Paint	OUTSIDE SERVICES	paint white D5425-043 job 168535	Firmed	1/31/18	1 Ea	0 Ea	1 Ea	\$225.00/Ea	\$225.00
2		Paint	OUTSIDE SERVICES	paint white D5425-043 job 170125	Firmed	1/31/18	1 Ea	0 Ea	1 Ea	\$225.00/Ea	\$225.00
3		Paint	OUTSIDE SERVICES	paint white D5466-1 job 171077	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
4		Paint	OUTSIDE SERVICES	paint white D5469-1 job 171080	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
5		Paint	OUTSIDE SERVICES	paint white D5468-1 job 171079	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
6		Paint	OUTSIDE SERVICES	paint white D5467-1 job 171078	Firmed	1/31/18	2 Ea	0 Ea	2 Ea	\$25.00/Ea	\$50.00
Grand Total:										\$650.00	

Order Notes

CL

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Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Purchasing Receipts

PO No	Supplier	Line Item No	Rel No	Terms	Purchased Item	Description	For Part No	Project	Equipment ID	Order Qty	Due Date	Received Quantity	Accounting Job No	Serial No	Status	Receive Date	Price/Unit	Aging Days	Past Due	Total	Suppl Nam
PO038908	ATE003-VC	1	1	Net 30	OUTSIDE SERVICES	paint white D5425-043 job 168535				1	1/31/2018	1			Inactive	1/31/2018	\$ 225.00 / Ea	0		\$225.00	Atelier Debosse
		2			paint white D5425-043 job 170125				1		Inactive	1/31/2018	\$ 225.00 / Ea	0		\$225.00	Atelier Debosse				
		3			paint white D5466-1 job 171077		2		2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Debosse				
		4			paint white D5469-1 job 171080				2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Debosse				
		5			paint white D5468-1 job 171079				2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Debosse				
		6			paint white D5467-1 job 171078				2		Inactive	1/31/2018	\$ 25.00 / Ea	0		\$50.00	Atelier Debosse				
		Total:										10		10							\$528.86

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